



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2666-1
Job Sheet 214411



Part No: D2666-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/20

Job Tracking No:

Due Date: 11/23/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	11/21/20		0.00	0.00	HAAS - 1	DAS 52	29/11/07
							HAAS - 2	9-89	
							HAAS - 3		
							HAAS - 4	DAS	
100	HAAS 4 Axis - B4B	4 pcs	11/21/20		0.63	3.66	HAAS - 1 - B4B	DAS 52	29/11/08
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B	DAS	
110	Conventional Mill - 1 - B4B	4 pcs	11/21/20		0.00	0.67	Conventional Mill - 1 - B4B	DAS 52	29/11/08
							Conventional Mill - 2 - B4B	9-89	
120	QC 2	4 pcs	11/21/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



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CANADA
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Container No: S311530



Part: D2666-1

Job No: 214411

Serial No/Batch: S311530

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Da

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				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	DAG
				QC 2 - 52	52 20/11/08
				QC 2 - 57	9-89
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	4	11/21/20	0.00 0.00	QC 8 - 12	
pcs				QC 8 - 14	7/20/11/09
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical-	4	11/21/20	0.00 0.21	Handfinish - 1 - 1 - B4B	
B4B	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	

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https://www.plexonline.com/5c422b8e-8157-4bb6-92fd-5f61c481481a/Plexus_Control/Report_View/2.asp?URL=https://www.plexonline.com/5c422b... 3/5

				Packaging 3 - 3 - B4B	DAS
				Packaging 3 - 4 - B4B	28
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	NOV 18 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	11/23/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	28
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	NOV 18 2020
				QC 21 - SA - 28	

Part Op 100 - HAAS CNC Vertical Machine - Program batch number.
 Descriptions: 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	5311219X1 5396736X2 5372753X1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-001	4	3	0

Part Specifications

Specifications could not be found.

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DART

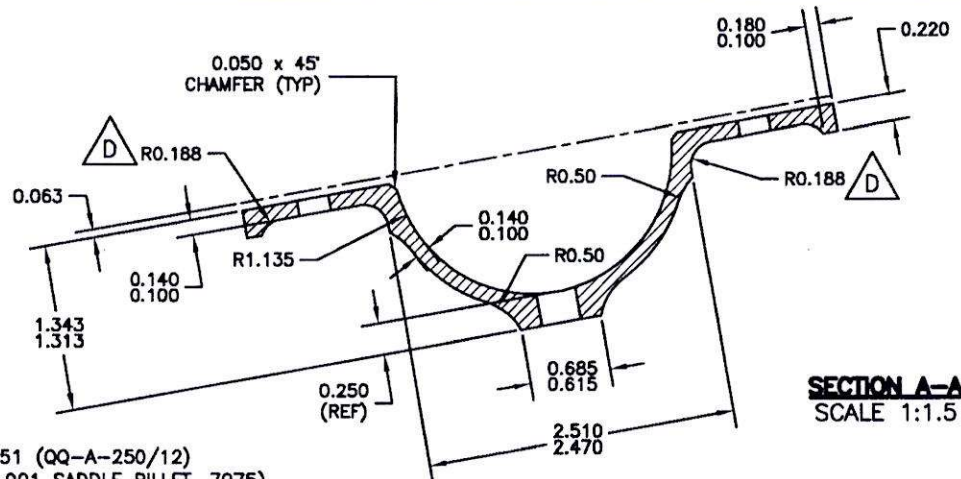
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

07.02.12 #

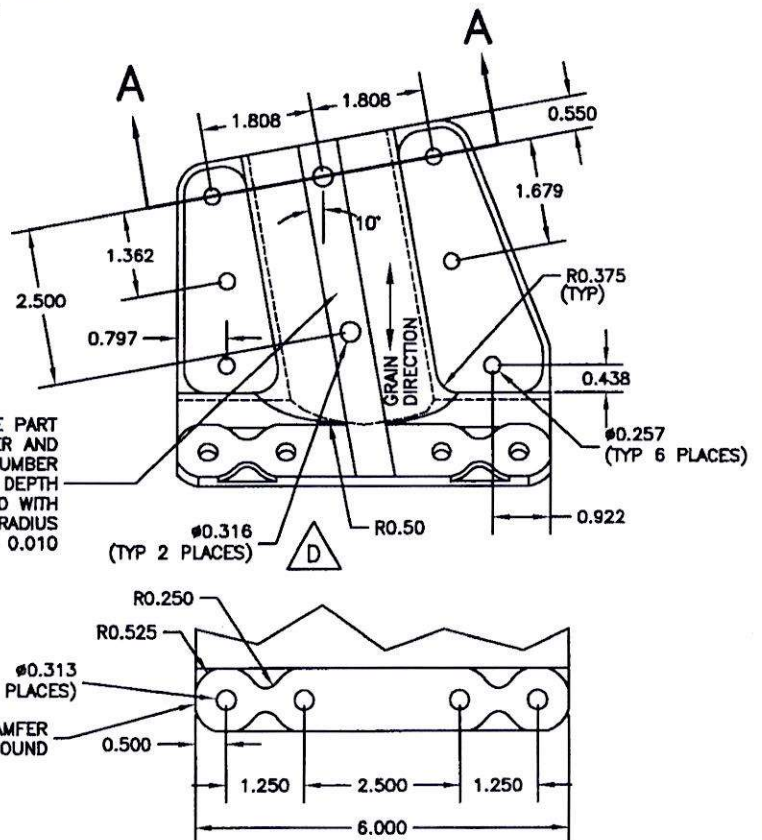
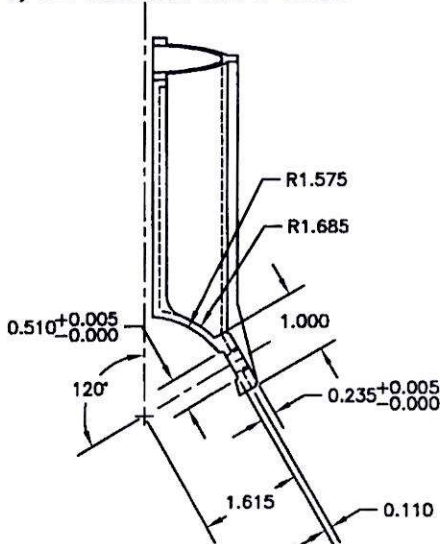
OCT 28 2020

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SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDERNO. 214411SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH

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DART AEROSPACE LTD		Work Order: 214411
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.124	0.124	0.125	0.125	
B	0.100	0.140		0.133	0.130	0.130	0.130	
C	2.470	2.510		2.490	2.490	2.490	2.490	
D	0.100	0.180		0.140	0.140	0.140	0.140	
E	0.210	0.230		0.221	0.220	0.221	0.222	
F	1.313	1.343		1.325	1.325	1.325	1.325	
G	0.240	0.260		0.254	0.252	0.252	0.251	
H	0.615	0.685		0.650	0.655	0.655	0.655	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.002	1.002	1.002	1.002	
K	0.235	0.240		0.239	0.238	0.238	0.238	
L	0.510	0.515		0.510	0.510	0.510	0.510	
M	0.100	0.120		0.120	0.118	0.115	0.115	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		6.002	6.002	6.002	6.002	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		0.502	0.499	0.500	0.500	
S	0.312	0.318		0.313	0.313	0.313	0.313	
T	2.495	2.505		2.499	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		0.316	0.316	0.316	0.316	
W	0.540	0.560		0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		0.258	0.258	0.258	0.258	
Z	0.178	0.198		0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 52	Date: 20/11/08
Audited by: 989	Date: 20/11/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					